

Work Order ID 68426

Wednesday, April 13, 2011 9:57:48 AM

Page 1

Item ID: D4016-1

Accept

Revision ID:

Item Name: Hinge Half, Base

Start Date: 4/13/2011 Start Qty: 18.00

Required Date: 4/19/2011 Req'd Qty: 18.00

Reference:

Approvals:

Process Plan:

Date: 4/10/13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4016	A

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 1.00" LONG

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA869 AND DWG
FOLIO REV:
DWG REV:

DEBURR

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Item ID:	D4016-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Hinge Half, Base					
Start Date:	4/13/2011	Start Qty:	18.00		Cust Item ID:	
Required Date:	4/19/2011	Req'd Qty:	18.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		11-4-19		18	0		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		2-11/04/20		18	0		
160 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00		SAP 1104-27		(10) 9			

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Item ID: D4016-1

Accept

Revision ID:

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Start Date: 4/13/2011 Start Qty: 18.00

Required Date: 4/19/2011 Req'd Qty: 18.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/28 [Signature]
MF
11-04-28

Picklist Print

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Page 1

Work Order ID: 68426

Parent Item: D4016-1

Parent Item Name: Hinge Half, Base



Start Date: 4/13/2011

Required Date: 4/19/2011

Start Qty: 18.00

Required Qty: 18.00

Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B
as per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B1.000X1.000

Purchased

No

100

f

13.8000

0.08

1.44



Handwritten: 11.4.19

304 bar 1.00 x 1.00

Location

Loc Qty

Loc Code

MAT050

13.8

113290 ✓

1.3

117130 ✓

12.5

Handwritten calculations:
13.8
- 2.5

11.3

Handwritten: 1.5 total

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

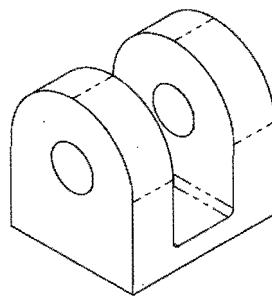
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

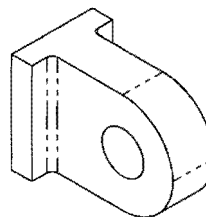
NOTE: Date & initial all entries

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 68424

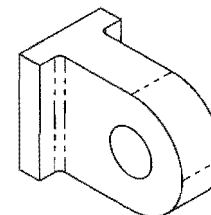
PL 11-04-13



D4016-1 HINGE HALF, BASE



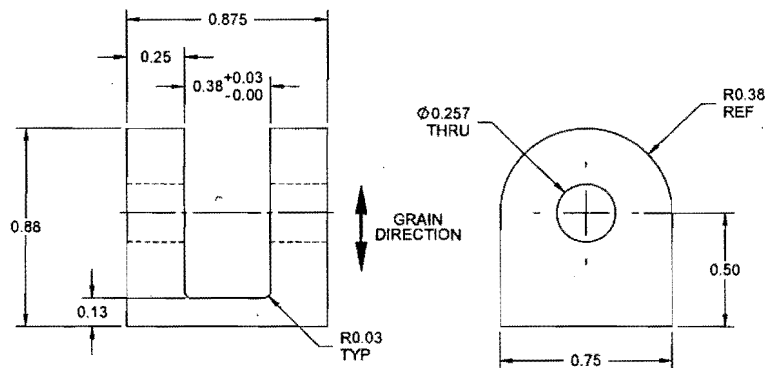
D4016-3 HINGE HALF, LID



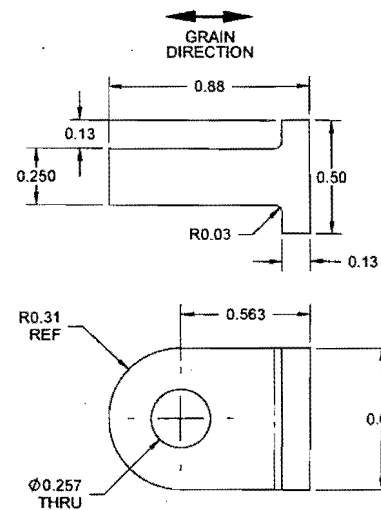
D4016-5 HINGE HALF, LIGHT LID

RELEASED
 2010-02-16
MD

A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4016	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET HINGE	NTS
DATE	10.01.29	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

NOTES:

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

RELEASED
2010-02-16

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4016	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 2	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET HINGE	NTS
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